

Date: Wednesday, 9/12/2007 11:42:38 AM
 User: Kim Johnston

Process Sheet

8/5
07/11/07

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL ASSEMBLY
 Job Number : 34553-1
 Estimate Number : 13010
 P.O. Number : N/A Part Number : D3245043
 This Issue : 9/12/2007 S.O. No. : N/A Drawing Number : D3245 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : A
 Previous Run : N/A Material : N/A
 Written By : Due Date : 10/5/2007 Qty: 8 Um: Each
 Checked & Approved By :
 Comment : Est Rev : A New Issue 07-09-11 JLM Verified By: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32457 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Gasket

Batch: B23281

mf

2.0 D32453 Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Door

Batch: B20763

mf

3.0 235120009C3Y STUD



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

STUD

Batch: m103476

x 10mx, m: 106198 x 6mx. mf

4.0 127H35 HALF GROMMET



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

HALF GROMMET

Batch: m18245

mf

07-11-12.

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Studs and Gromets as per Dwg D3245

3-Bond Gasket using 3M ADHESIVE as per Dwg D3245

mf 07-11-12

(2)

Date: Wednesday, 8/12/2009 11:42:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34553

Part Number: D3245043

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R 3M 13000/1300L ADHESIVE Batch: m102 890

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/11/12 (2)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6/7/12 (2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/1/13

Job Completion

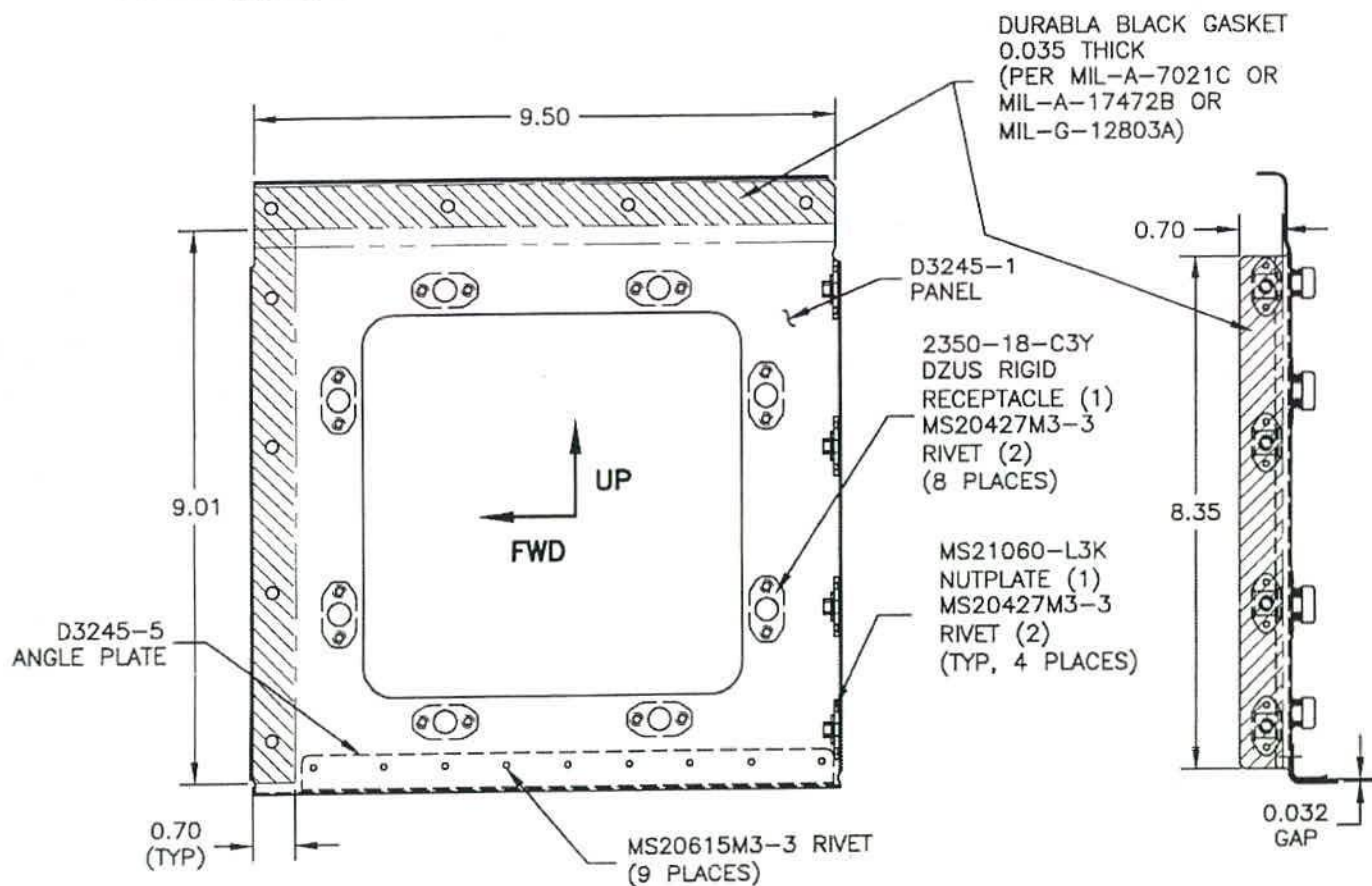


U 8/11/13

DART

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CHECKED	H	APPROVED	H	DRAWING NO. D3245	REV. A SHEET 1 OF 6
DATE	04.01.27	TITLE ACCESS PANEL ASSEMBLY			SCALE 1:3
A	04.01.27	NEW ISSUE			

RELEASED
04 04 21 H



D3245-041 ACCESS PANEL ASSEMBLY

D3245-041 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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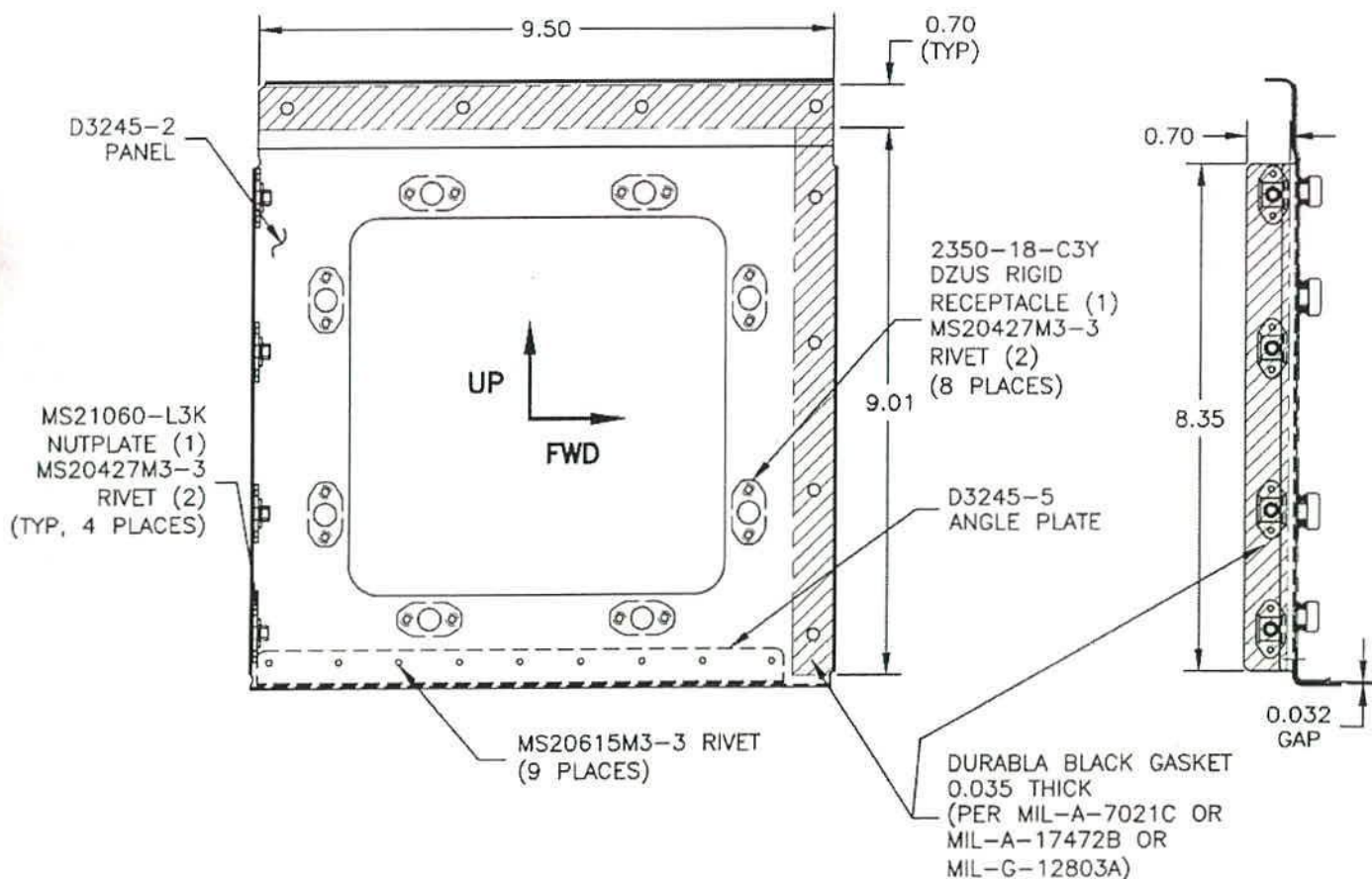
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DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3

RELEASED
04.01.27



D3245-042 ACCESS PANEL ASSEMBLY

D3245-042 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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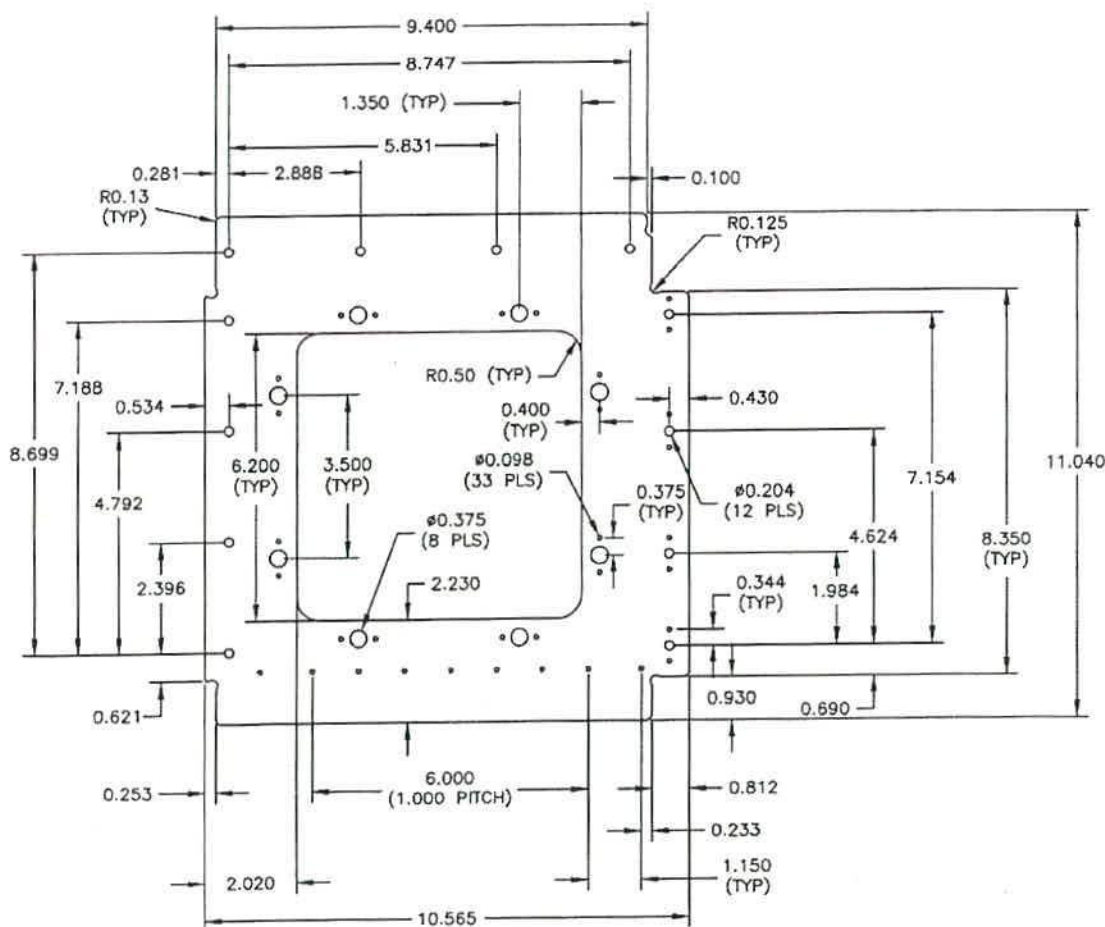
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				REV. A
DATE	04.01.27	TITLE	ACCESS PANEL ASSEMBLY	SHEET 4 OF 6
				SCALE 1:4

RELEASED
04.04.21 *[Signature]*



D3245-1/-2 PANEL FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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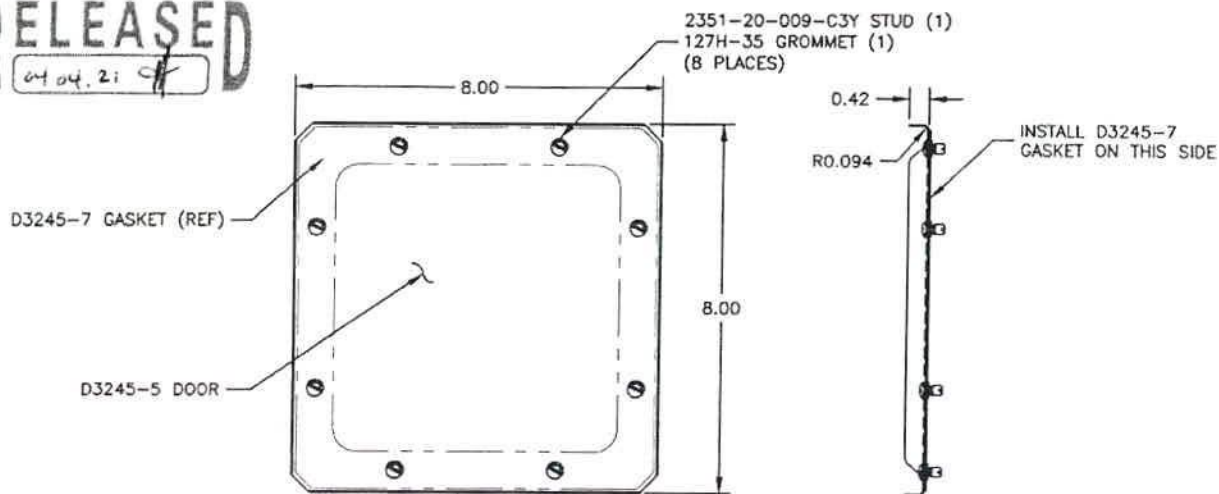
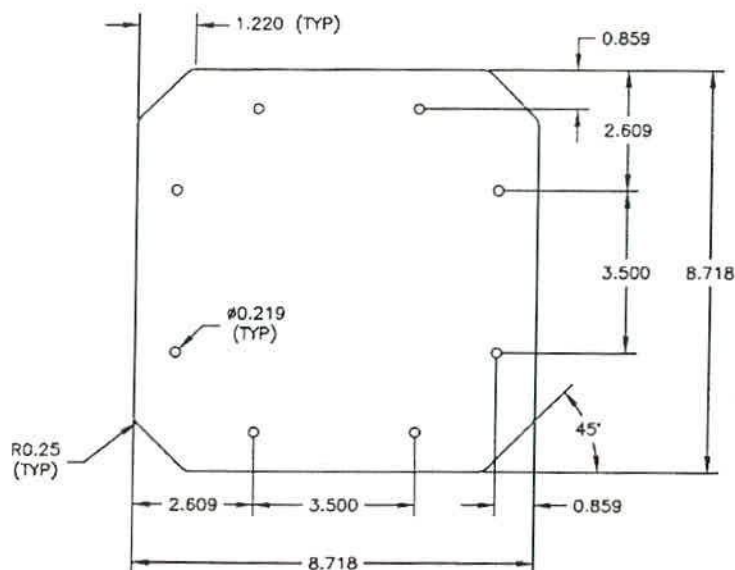
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

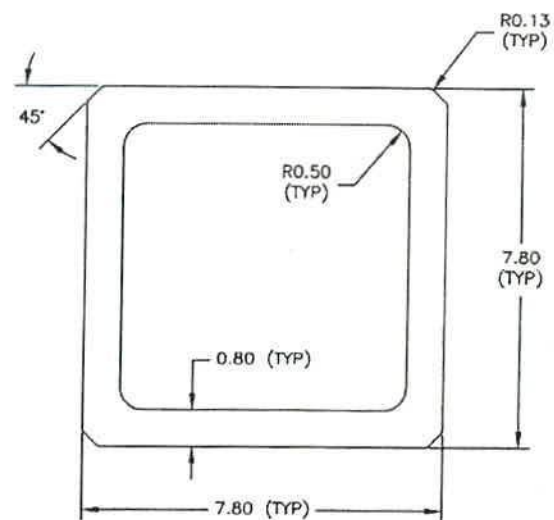
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04.01.27

**D3245-043 DOOR ASSEMBLY****D3245-3 DOOR FLAT PATTERN**

MATERIAL: AISI 304/316 SS 0.032 THICK
ANNEALED (REF. M304S22GA)

D3245-043 NOTES:

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

**D3245-7 GASKET**

MATERIAL: DURABLE BLACK GASKET 0.035 THICK
(PER. MIL-A-7021C OR MIL-A-17472B
OR MIL-G-12803A)

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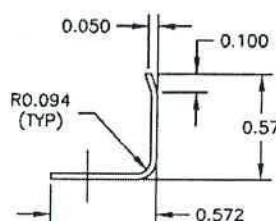
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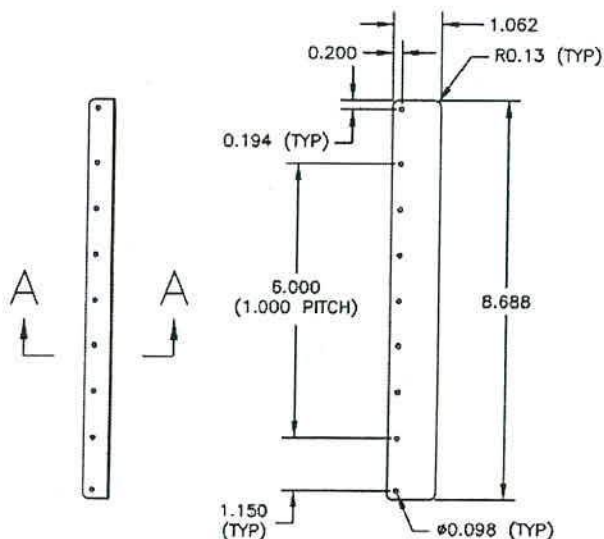


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RELEASED
04-04-05



D3245-5 BEND DETAIL
VIEW A-A
SCALE 1:1



D3245-5 FLAT PATTERN

D3245-5 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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